

Work Order ID 59263

Friday, May 28, 2010 9:53:49 AM



Page 1

Item ID: D2506

Accept



Setup Start



Revision ID:

Item Name: Label Plate

Stop



Start Date: 5/28/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten initials

Date: *10528*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2506

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2506

☐ Dwg Rev: *F*

☐ Prog Rev: *F*

☐ 2-

Debur if necessary

304. 040

B 10-6-1

(5)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-6-1

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Scrubbing

(x5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo 1-Form as per dwg D2506	0.00 0.00		SB 10106/02		5			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Siob661a		5			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		SAP 10-06-02		5			

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Required Date: 6/4/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/02 [Signature]
CZ 10/6/12

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Picklist Print

Friday, May 28, 2010 9:53:53 AM

Page 1

Work Order ID: 59263



Parent Item: D2506



Parent Item Name: Label Plate

Start Date: 5/28/2010

Required Date: 6/4/2010

Comments: IPP B ☐ 01.06.08 ☐ Now laser cut ☐ EC ☐

Start Qty: 5.00

Required Qty: 5.00

IPP C 06.12.13 ecn 822 ec

IPP Rev:D 08-12-01 rev.F as per dwg DD verified by:

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M304S20GA		Purchased	No			100	sf	172.9926	1.22	6.421053			
304/316 .040 Sheet													



1810-6-1

Location	Loc Qty	Loc Code
MAT	168.7278	
114574	168.7278	
MAT20	4.2648	
112885	2.7475	
113062	1.5173	

114574

5

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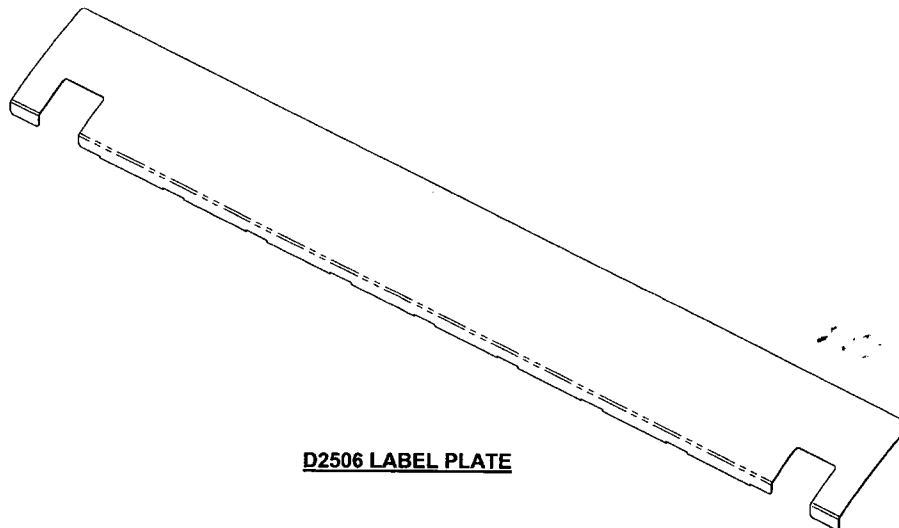
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D2506 LABEL PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59263
ADRO-5-28

RELEASE
08/11/18 MD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 \triangle
REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.92 lbs

F	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT; UPDATED NOTE 1 (ZN A6-1); ADDED DETAIL A (ZN C8-2); 124" \pm 1" WAS 127" (ZN A4-2) REASONS: EASE MANUFACTURING WITH CORRECTION OF BEND AND ADDITION OF INTERMITTENT WELDING LOCATORS	MB	08.09.23
E	REMOVE 10" BEND; ADD NOTES; 127" WAS 126"	CB	06.11.20
D	32.63 WAS 32.25; 1.31 WAS 1.50	KE	99.10.04
C	RE-DESIGN OF LABEL PLATE	MM	96.09.04
B	RE-DESIGN OF LABEL PLATE	MM	96.06.18
A	NEW ISSUE	KH	95.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>JS</u>		
CHECKED	<u>JS</u>	DRAWING NO.	REV. F
MFG. APPR.	<u>JS</u>	D2506	SHEET 1 OF 2
APPROVED	<u>JS</u>	TITLE	SCALE
DE APPR.	<u>JS</u>	LABEL PLATE	NTS
DATE	08.09.23	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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